

slp Friday Jan 6

Work Order ID 78341

78341

Page 1

January-05-12 1:47:52 PM

Item ID: D2195

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 1/05/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/06/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: W

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2195	Rev D								

100

0.00

100

Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

CP 12/01/06 (1)

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

AL 12-01-06 (1)

120

0.00

120

Powdercoat

Memo

0.00

Powder Coating

XJ M-L 12/01/09

W119480

Start Time: 2:45
Temp: 400°F
Finish Time: 3:15

Work Order ID 78341***78341***

Page 2

January-05-12 1:47:52 PM

Item ID: D2195

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 1/05/12

Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/06/12

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00

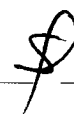
130

QC

Memo

0.00

Quality Control

12/1/9 

140

Identify as per dwg & Stock Location: _____

0.00


140

Packaging

Memo

0.00

Packaging

12/1/9 

150

QC21- Final Inspection - Work Order Release

0.00

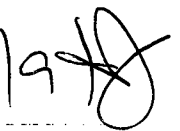
150

QC

Memo

0.00

Quality Control

12/1/9 MF
12-01-09

Picklist Print

January-05-12 1:47:51 PM

Page 1

Work Order ID: 78341

Parent Item: D2195

Parent Item Name: Bracket

Start Date: 1/05/12

Required Date: 1/06/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 12.01.05 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2195-1 Bracket		Manufactured	No			100	Each	4.0000	1	1		1/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		2							
				60928		2							
				Mezz		2							
				40763		2							
D2195-2 Bracket		Manufactured	No			100	Each	3.0000	1	1		1/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		1							
				60929		1							
				Mezz		2							
				40761		2							
D2195-3 Spacer		Manufactured	No			100	Each	4.0000	1	1		1/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		1							
				40762		1							
				ST005		3							
				60930		3							
MS20470AD4-14 Rivet		Purchased	No			100	Each	220.0000	6	6		1/5/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST320		220							
				1046		170							
				109059		50							

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D2195	BRACKET ASSEMBLY
7	1	D2195-1	BRACKET
8	1	D2195-2	BRACKET
9	1	D2195-3	SPACER
15	6	MS20470AD4-14	RIVET

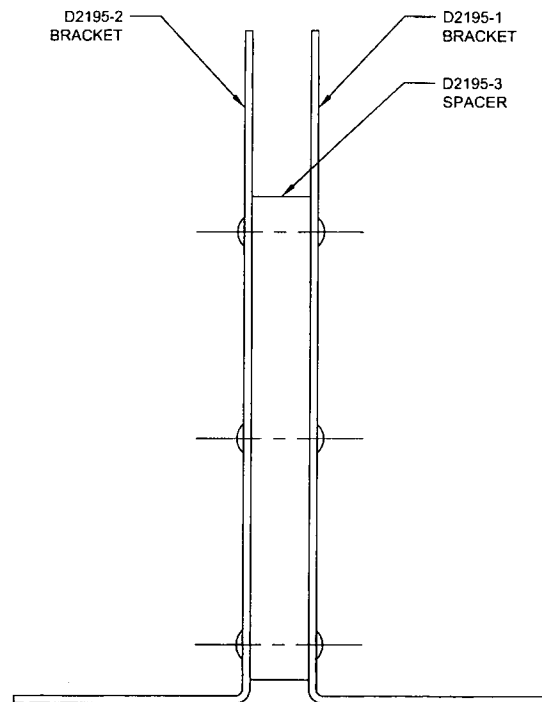
NOTES:

- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

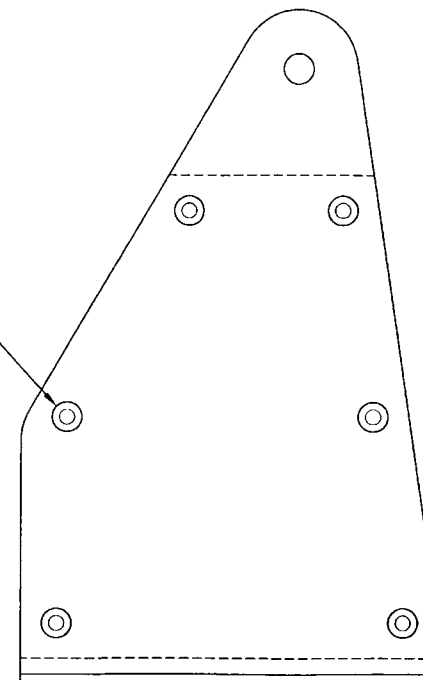
D	RE-DESIGN. REF NCR 08-110.	AJS	08.11.25
C	REDRAW: D2195-3 NOW 0.5" THICK	CP	03.05.28
B	RE-DESIGN	JB	93.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2195	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

RELEASED
09/01/94

w/67834



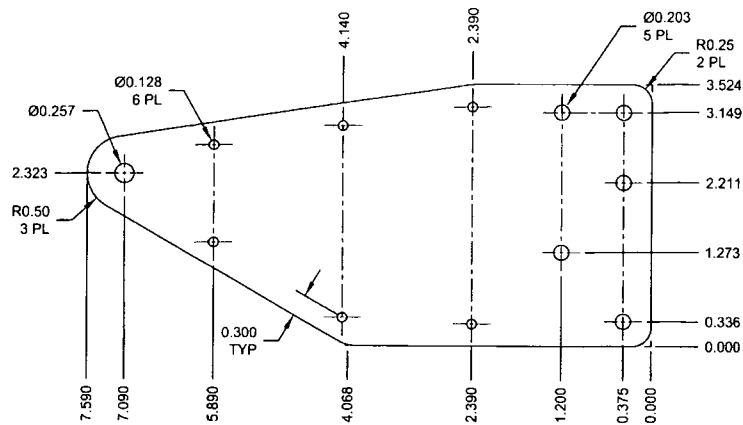
MS20470AD4-14
RIVET
6 PL



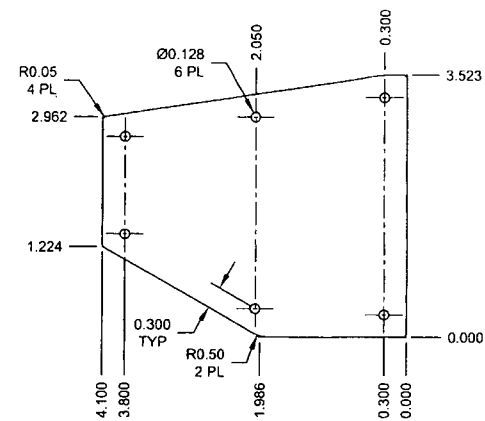
D2195 BRACKET ASSEMBLY

RELEASED
27/01/15

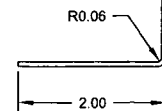
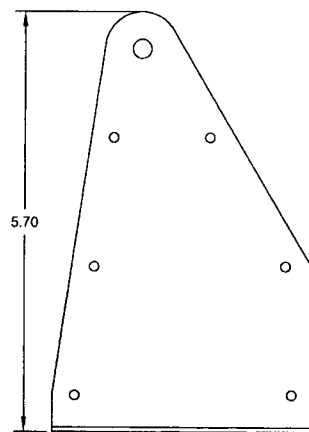
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DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2195	SHEET 2 OF 3
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	BRACKET	NTS
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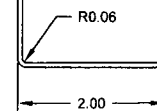
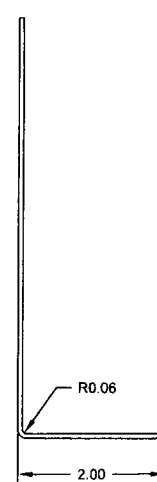
D2195-1F BRACKET FLAT PATTERN



D2195-3 SPACER



D2195-2 BRACKET
MAKE FROM D2195-1F







D2195-1 BRACKET
MAKE FROM D2195-1F

NOTES:

- 1) MATERIAL: -1 & -2: AISI 304/316 S.S. SHEET, 0.064 THICK
PER AMS 5513 OR AMS 5524
REF. DART SPEC M304S
- 3: 5052-H32 ALUMINUM SHEET, 0.500 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.500
- 2) FINISH: -3 ONLY: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHT

RELEASED
07/01/15

DESIGN	JB	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D2195	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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